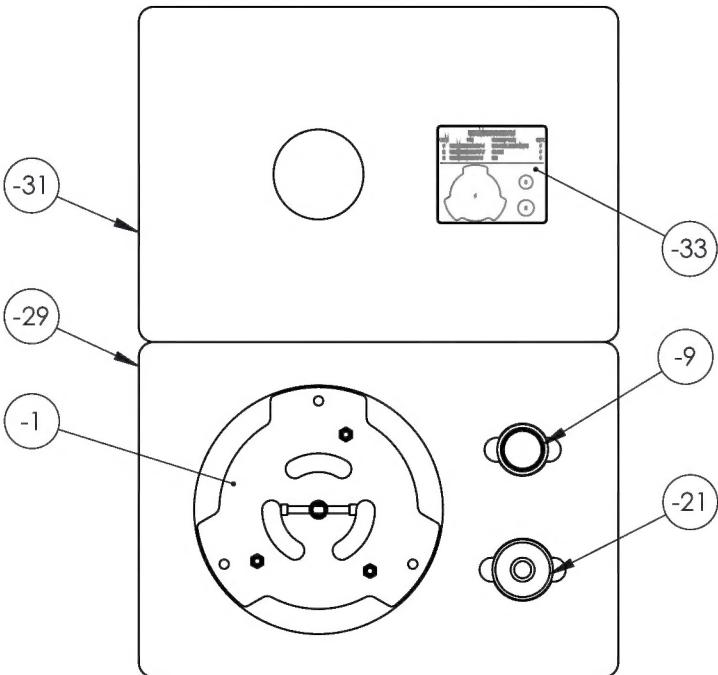


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REVISIONS					
REV	ECR	DESCRIPTION		DATE	INITIAL
1		RELEASED FOR PRODUCTION.		7/19/2016	SM JAG



ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	1	IGB SEAL EXCHANGE			2
1			-3		PLATE	6061		3
3			-5		SPACER	A36/1018/1020 HR		4
1	B/O	-7			BAR-HANDLE NUT	STEEL	M10 (CARR-LANE #CLM-10-BHN)	2
		-9	1		GUIDE	6061		5
1	B/O	-11			CAP	4140/4142 Q & T		6
1	B/O	-13			SPRING PIN	STEEL	Ø3/16 X 3/4 (MCMASTER-CARR #90692A723)	2
1	B/O	-15			THREADED INSERT	S.S.	M10 X 1.5 (MCMASTER-CARR # 93715A625)	2
3	B/O	-17			SPRING PIN	STEEL	M2 X 12MM (MCMASTER-CARR # 91611A105)	2
3	B/O	-19			CASTLE NUT	STEEL	M8 X 1.25 (MCMASTER-CARR # 93760A222)	2
		-21	1		LID	A36/1018/1020 HR		7
X		-23	1		FOOT WELDMENT			8
1		-25			STUD	STEEL	M10X1.5 X 80mm (MCMASTER-CARR #94595A222) MOD.	9
1		-27			FOOT	4140/4142 Q & T		10
	B/O	-29	1		FOAM, BOTTOM	Y-20, BLACK	19.97 x 13.97 x 8.00 (I.R. SPECIALTY)	11
	B/O	-31	1		FOAM, TOP	Y-20, BLACK	19.97 x 13.97 x 1.95 (I.R. SPECIALTY)	12
		-33	1		PLACARD	PLASTIC		13
	B/O	-35	1		CASE	PLASTIC	PELICAN #APP-IM2620-E	N/S
	B/O		1		DART PLACARD	ALUMINUM	RB41011	N/S
ASSY -23	ASSY -1							

NOTE:
1. REF. AIRBUS T/N: M653V3003101, REV A.



TITLE IGB INPUT SEAL EXCHANGE

DWG NO. RBEM653V3003101

REV 1

MAT'L UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
HEAT TREAT .XXX ± .005 FRACTIONS ± 1/8
FINISH .XX ± .01 ANGLES ± 5°
X ± .1 SURFACES = 125

1. BREAK ALL SHARP EDGES
.015 x 45° OR .015R

2. DIMENSIONAL LIMITS APPLY

AFTER PLATING

3. INTERPRET DIM AND TOL PER

ASME Y14.5M-2009

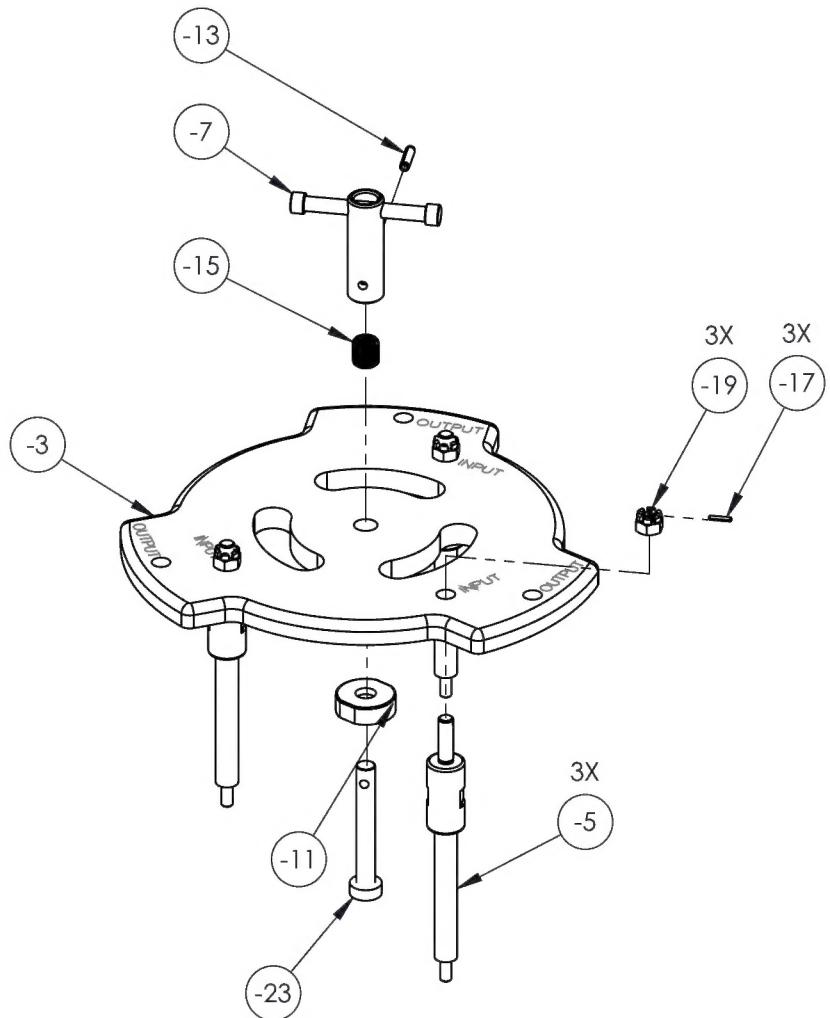
QA APPR: LINDSAY USED ON MODEL

APPROVED: GILBERT H175

SCALE 1:8 DATE 4/13/2016 SHEET 1 OF 13

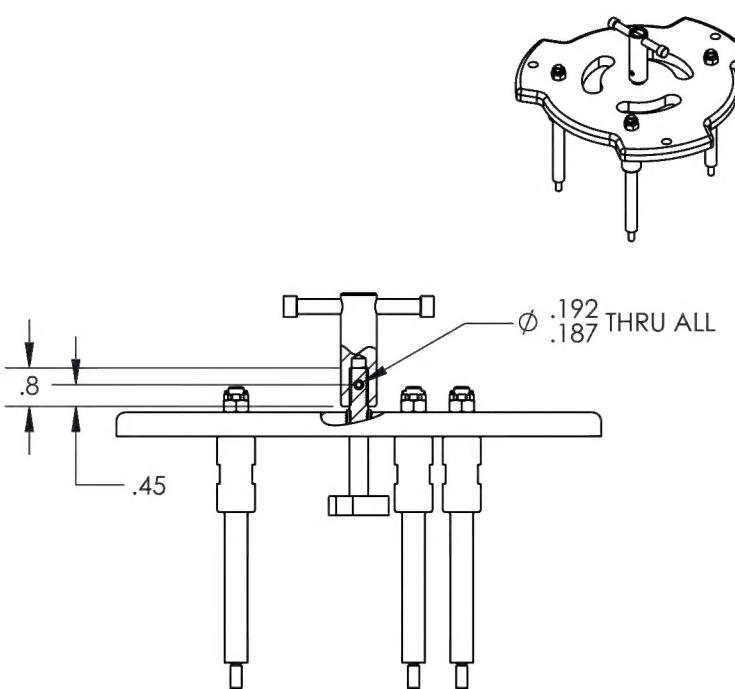
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REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
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(-1)

IGB SEAL EXCHANGE



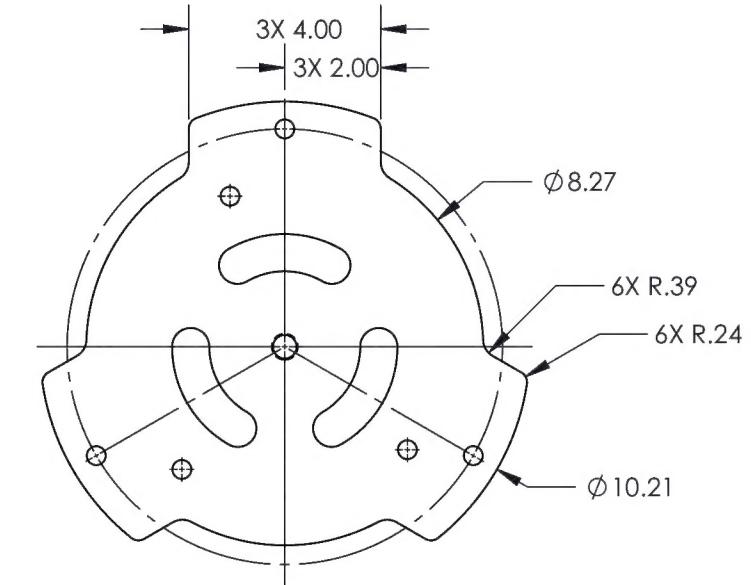
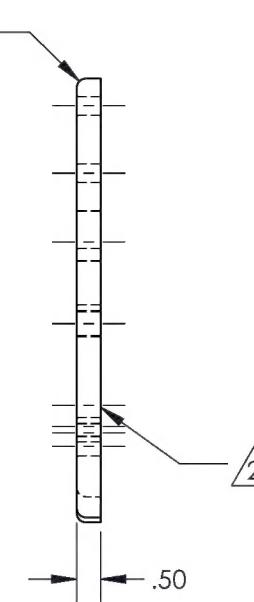
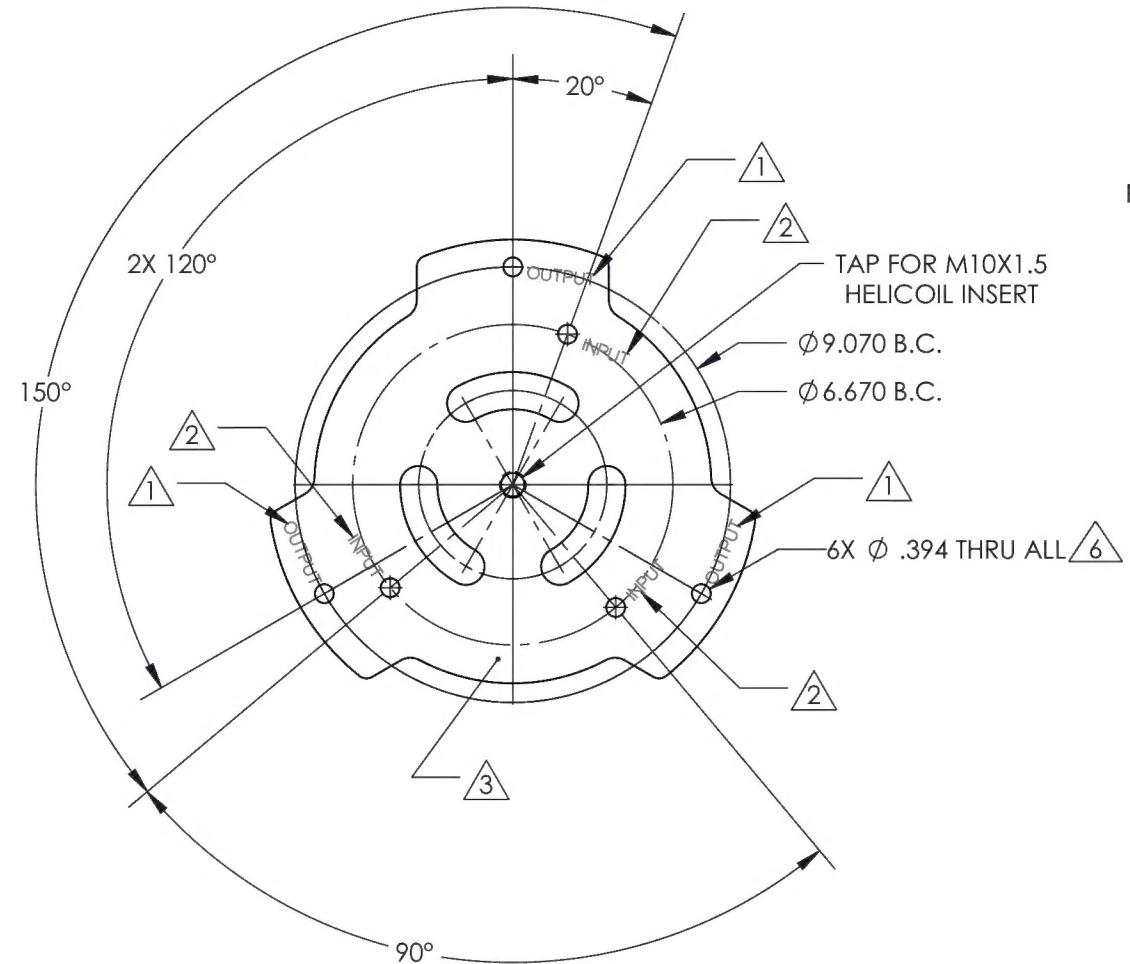
NOTES:

1. -5 MUST ROTATE FREELY UPON COMPLETE ASSEMBLY.



TITLE
IGB INPUT SEAL EXCHANGE

DWG NO.	RBEM653V3003101-1	REV 1
MAT'L	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT	.XXX ± .005	FRACTIONS ± 1/8
TREAT	.XX ± .01	ANGLES ± 5°
FINISH	X ± .1	SURFACES = 125
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
DRAWN BY:	MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED:	DUERFELDT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR:	ANDERSON	USED ON MODEL
QA APPR:	LINDSAY	
APPROVED:	GILBERT	H175
SCALE	1:4	DATE 4/13/2016
		SHEET 2 OF 13



NOTES:

- 1) MACHINE ENGRAVE "OUTPUT" FILL WITH BLACK INK.
- 2) MACHINE ENGRAVE "INPUT" FILL WITH BLACK INK.
- 3) INK STAMP T/N, S/N, "MADE IN USA".
- 4. USE CAD DATA TO MANUFACTURE.
- 5. FINISH:
 - 1) CLEAR ANODIZE SPEC. MIL-A-8625F, TYPE II, CLASS I.
 - 2) POWDER COAT YELLOW SPEC. FED# 13538.
- 6) DO NOT POWDER COAT SURFACE.

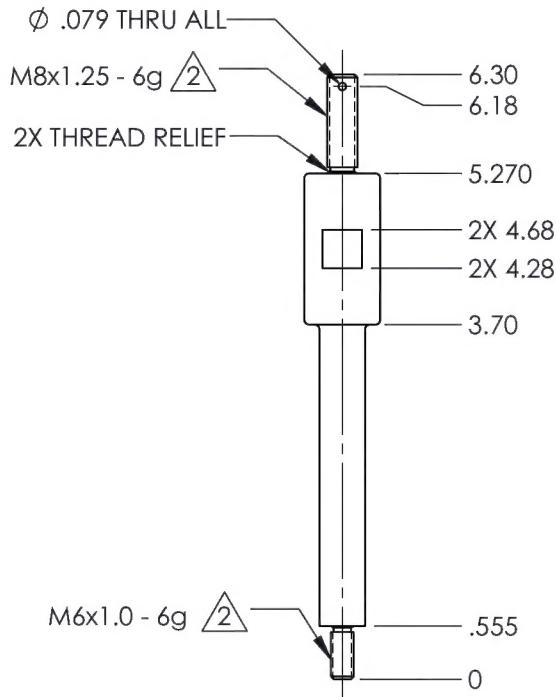
(-3)

PLATE

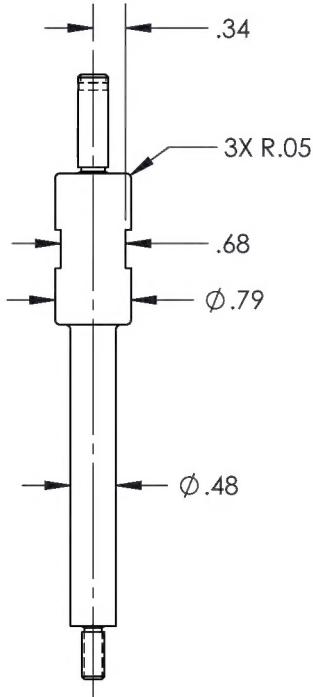
DART AEROSPACE	
TITLE	
IGB INPUT SEAL EXCHANGE	
DWG NO.	RBEM653V3003101-3
REV	1
MATERIAL 6061 UNLESS OTHERWISE SPECIFIED	
DIMENSIONS ARE IN INCHES	
.005 ± .005 FRACTIONS ± 1/8	
HEAT	XXX ± .005
TREAT	XX ± .01
FINISH	ANGLES ± .5°
SPEC	X ± .1 SURFACES = 125
1. BREAK ALL SHARP EDGES ✓	
DRAWN BY:	MACKOVJAK
CHECKED:	DUERFELDT
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	H175
SCALE	1:4
DATE	4/13/2016
SHEET 3 OF 13	

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REV	ECR	REVISIONS	DESCRIPTION	DATE	INITIAL	APPROVED
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(-5)
SPACER



NOTES:

1. DUAL FINISH:
1ST: ZINC PLATE, ASTM B633 TYPE I SC2.
2ND: POWDER COAT YELLOW SPEC. FED#13538.

2) DO NOT POWDER COAT THREADS.

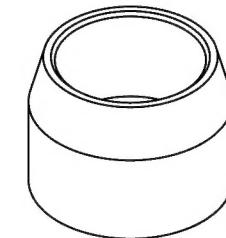
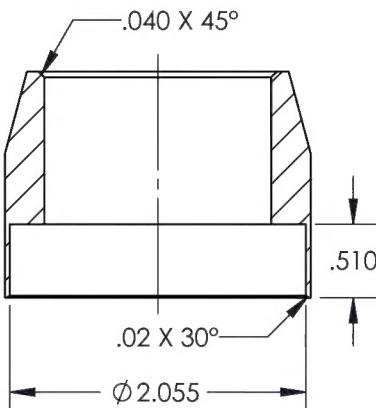
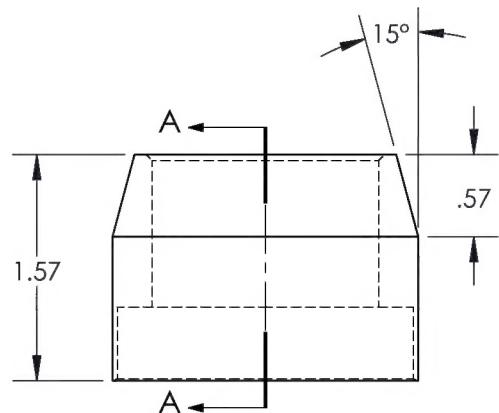


TITLE
IGB INPUT SEAL EXCHANGE

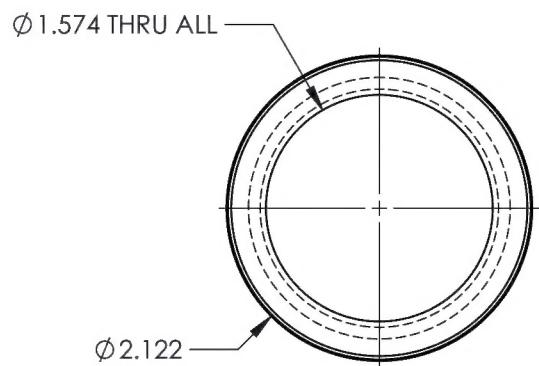
DWG NO.	RBEM653V3003101-5		REV 1
MAT'L	A36/1018/1020 HR		
HEAT	UNLESS OTHERWISE SPECIFIED		
TREAT	DIMENSIONS ARE IN INCHES		
FINISH	.XXX ± .005 FRACTIONS ± 1/8		
SEE NOTE 1	.XX ± .01 ANGLES ± 5°		
SPEC	X ± .1 SURFACES = 125 ✓		
DRAWN BY:	MACKOVJAK		
CHECKED:	DUFERFELDT		
OPPS APPR:	ANDERSON		
QA APPR:	LINDSAY		
APPROVED:	GILBERT		
USED ON MODEL	H175		
SCALE	1:2	DATE	4/13/2016
			SHEET 4 OF 13

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SECTION A-A



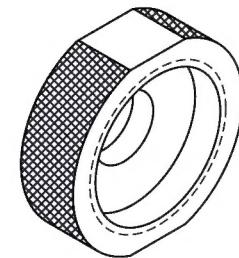
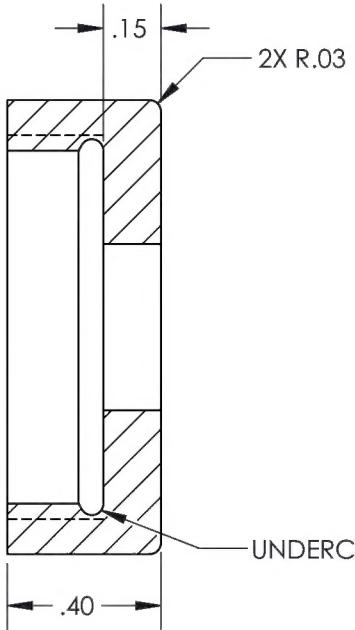
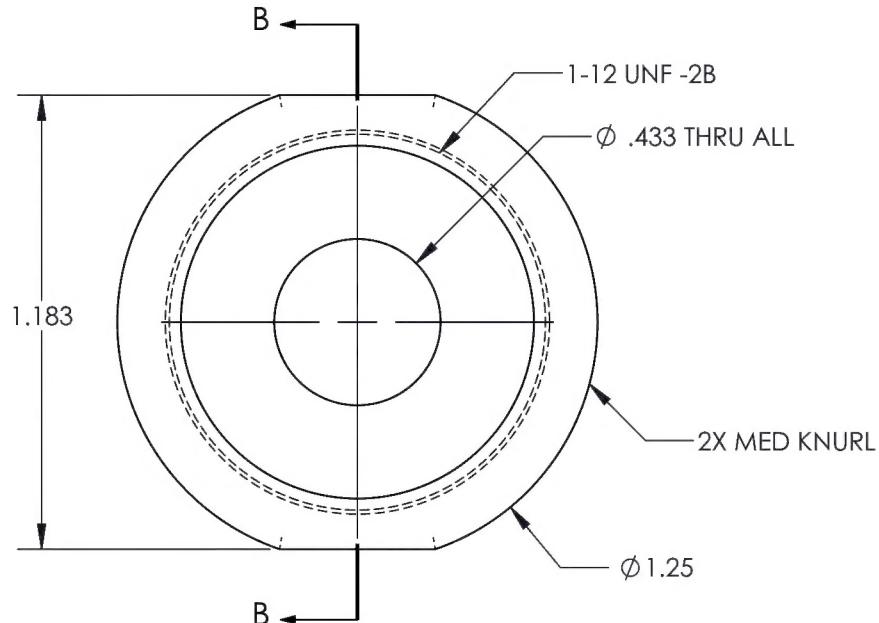
(-9)

GUIDE

DART AEROSPACE	
TITLE	
IGB INPUT SEAL EXCHANGE	
DWG NO.	
RBEM653V3003101-9	
REV	
1	
MAT'L 6061	
HEAT	
TREAT	
FINISH CLEAR ANODIZE	
SPEC MIL-A-8625F, TYPE II, CLASS I	
DRAWN BY: MACKOVJAK	
CHECKED: DUERFELDT	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
USED ON MODEL	
H175	
UNLESS OTHERWISE SPECIFIED	
DIMENSIONS ARE IN INCHES	
.XXX ± .005 FRACTIONS ± 1/8	
.XX ± .01 ANGLES ± 5°	
.X ± .1 SURFACES = 125	
1. BREAK ALL SHARP EDGES	
.015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY	
AFTER PLATING	
3. INTERPRET DIM AND TOL PER	
ASME Y14.5M-2009	
SCALE	3:4
DATE	4/13/2016
SHEET 5 OF 13	

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REV	ECR	REVISIONS	DESCRIPTION	DATE	INITIAL	APPROVED
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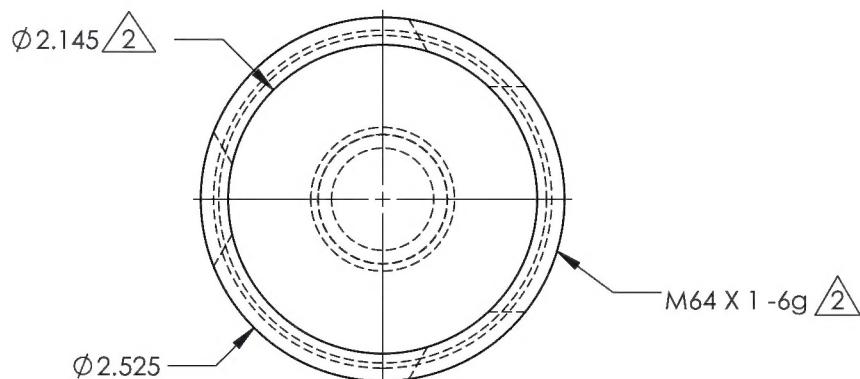
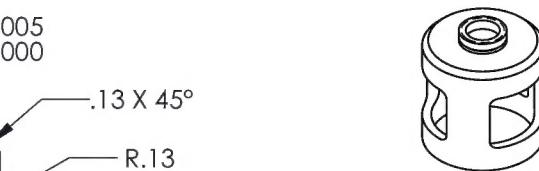
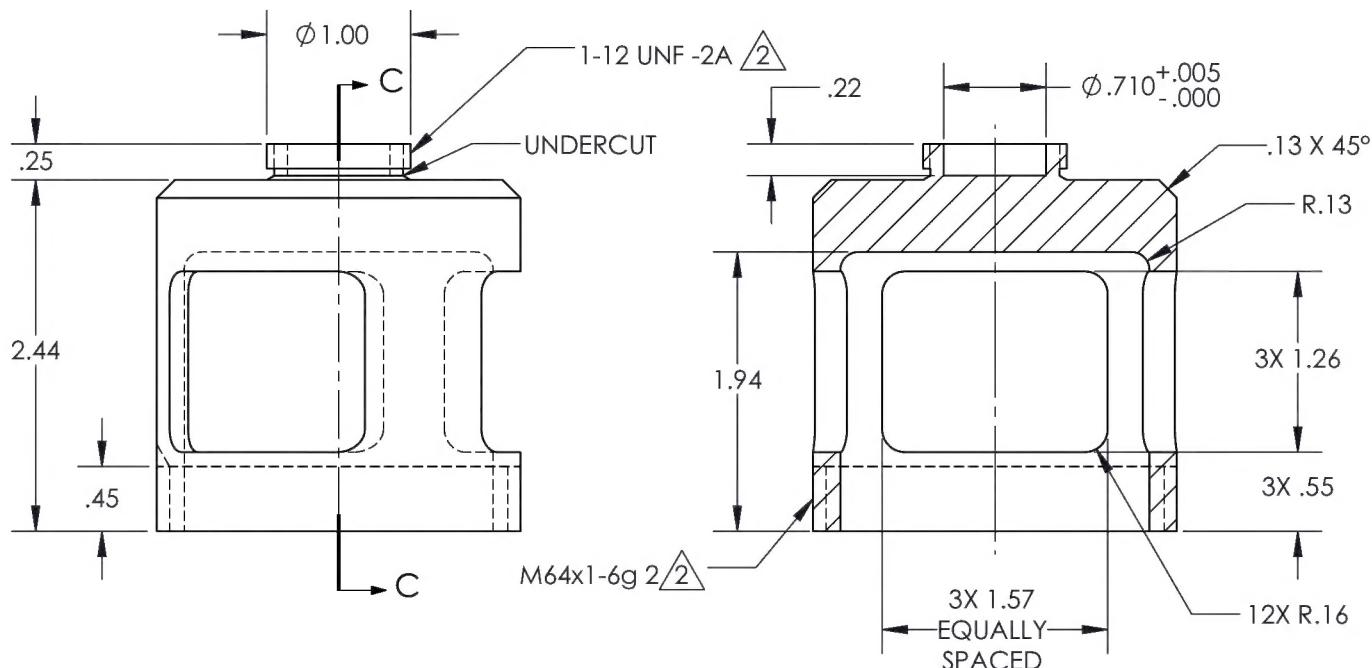
(-11)

CAP

	
TITLE	IGB INPUT SEAL EXCHANGE
DWG NO.	RBEM653V3003101-11
REV	1
MAT'L	4140/4142 Q & T
HEAT	UNLESS OTHERWISE SPECIFIED
TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 5°
	X ± .1 SURFACES = 125 ✓
DRAWN BY:	MACKOVJAK
CHECKED:	DUERFELDT
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	H175
SCALE	2:1
DATE	4/13/2016
SHEET 6 OF 13	

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REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
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(-21)

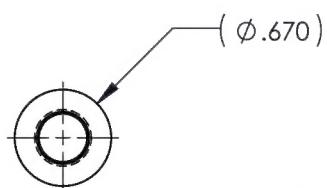
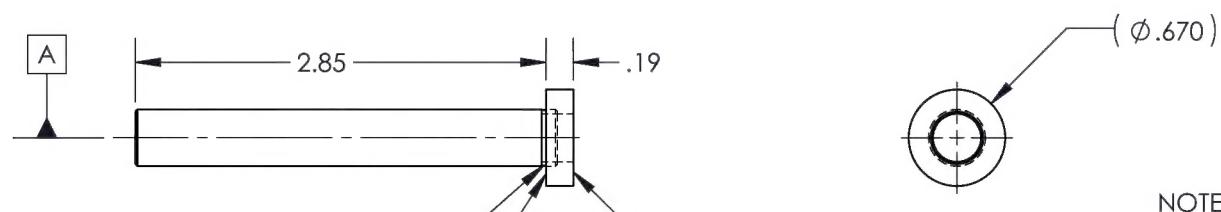
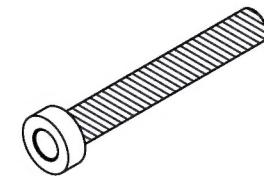
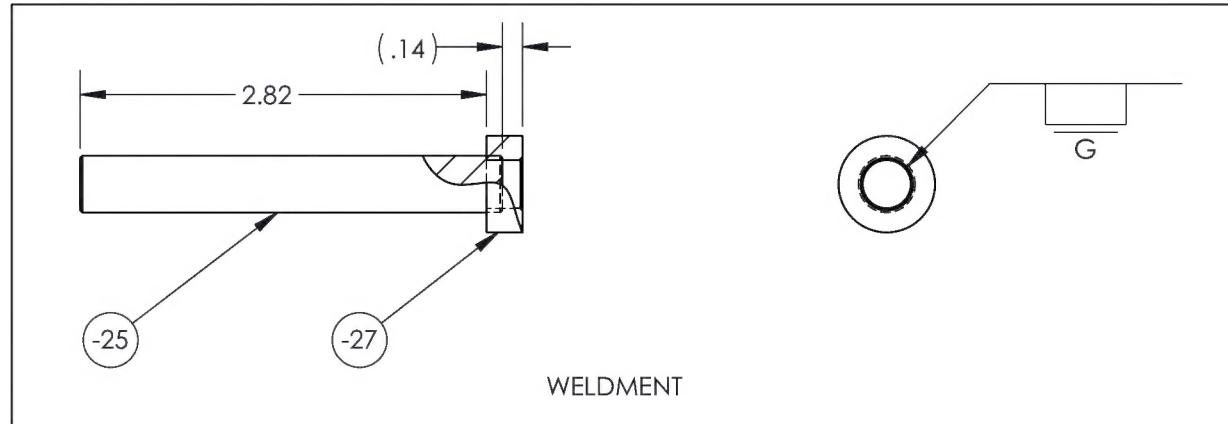
LID

NOTES:
 1. DUAL FINISH:
 1ST: ZINC PLATE, ASTM B633 TYPE I SC2.
 2ND: POWDER COAT YELLOW SPEC. FED#13538.
 2) DO NOT POWDER COAT THREADS OR SURFACE.

DART AEROSPACE											
IGB INPUT SEAL EXCHANGE											
DWG NO. RBEM653V3003101-21 REV 1											
<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 50%;">MATERIAL A36/1018/1020 HR</td> <td style="width: 50%;">UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES</td> </tr> <tr> <td>HEAT</td> <td>.XXX ± .005 FRACTIONS ± 1/8</td> </tr> <tr> <td>TREAT</td> <td>.XX ± .01 ANGLES ± 5°</td> </tr> <tr> <td>FINISH SEE NOTE 1</td> <td>X ± .1 SURFACES = 125 ✓</td> </tr> <tr> <td>SPEC</td> <td></td> </tr> </table>		MATERIAL A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	HEAT	.XXX ± .005 FRACTIONS ± 1/8	TREAT	.XX ± .01 ANGLES ± 5°	FINISH SEE NOTE 1	X ± .1 SURFACES = 125 ✓	SPEC	
MATERIAL A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES										
HEAT	.XXX ± .005 FRACTIONS ± 1/8										
TREAT	.XX ± .01 ANGLES ± 5°										
FINISH SEE NOTE 1	X ± .1 SURFACES = 125 ✓										
SPEC											
DRAWN BY: MACKOVJAK	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R										
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING										
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009										
QA APPR: LINDSAY	USED ON MODEL										
APPROVED: GILBERT	H175										
SCALE 3:4	DATE 4/13/2016										
SHEET 7 OF 13											

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REV	ECR	REVISIONS	DESCRIPTION	DATE	INITIAL	APPROVED
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-23

FOOT WELDMENT

NOTES:
1. COMPLETE WELDMENT PRIOR TO MACHINING.

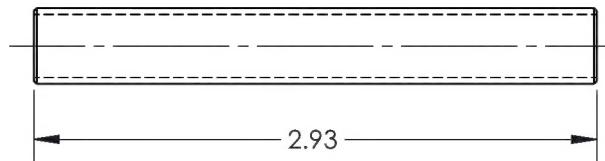
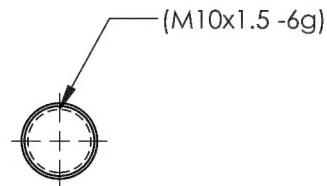
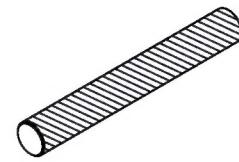
DART
AEROSPACE

TITLE
IGB INPUT SEAL EXCHANGE

DWG NO.	RBEM653V3003101-23	REV
MAT'L	UNLESS OTHERWISE SPECIFIED	
HEAT	DIMENSIONS ARE IN INCHES	
TREAT	.XXX ± .005	FRACTIONS ± 1/8
FINISH	.XX ± .01	ANGLES ± 5°
SPEC	ZINC PLATE	
DRAWN BY:	MACKOVJAK	X ± .1
CHECKED:	DUERFELDT	SURFACES = 125 ✓
OPPS APPR:	ANDERSON	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
QA APPR:	LINDSAY	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
APPROVED:	GILBERT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE	3:4	USED ON MODEL
DATE	4/13/2016	SHEET 8 OF 13

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REV		ECR		DESCRIPTION			DATE	INITIAL	APPROVED
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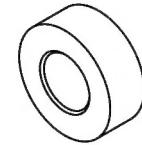
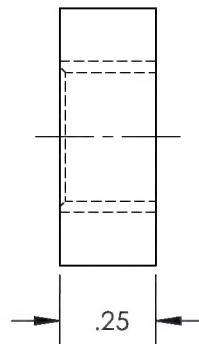
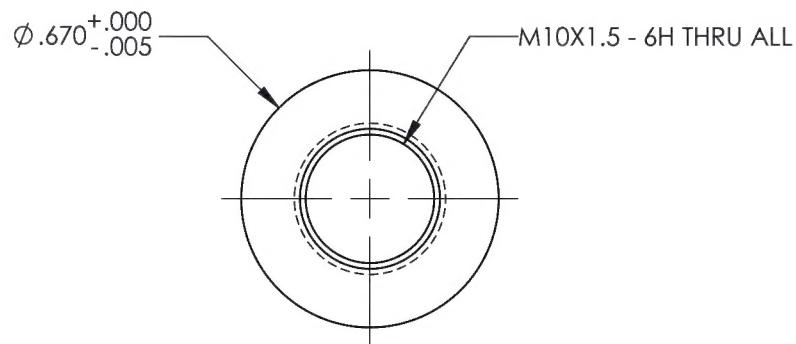
(-25)

STUD

TITLE		DART AEROSPACE	
		IGB INPUT SEAL EXCHANGE	
DWG NO.		RBEM653V3003101-25	
REV		1	
MATERIAL		STEEL	
HEAT		UNLESS OTHERWISE SPECIFIED	
TREAT		DIMENSIONS ARE IN INCHES	
FINISH SEE -23		.XXX ± .005 FRACTIONS ± 1/8	
SPEC		.XX ± .01 ANGLES ± 5°	
DRAWN BY:		X .01 SURFACES = 125 ✓	
CHECKED:		.015 x 45° OR .015R	
OPPS APPR:		2. DIMENSIONAL LIMITS APPLY	
QA APPR:		AFTER PLATING	
APPROVED:		3. INTERPRET DIM AND TOL PER	
		ASME Y14.5M-2009	
USED ON MODEL			
H175			
SCALE 1:1		DATE 4/13/2016	
		SHEET 9 OF 13	

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REV		ECR		DESCRIPTION			DATE	INITIAL	APPROVED
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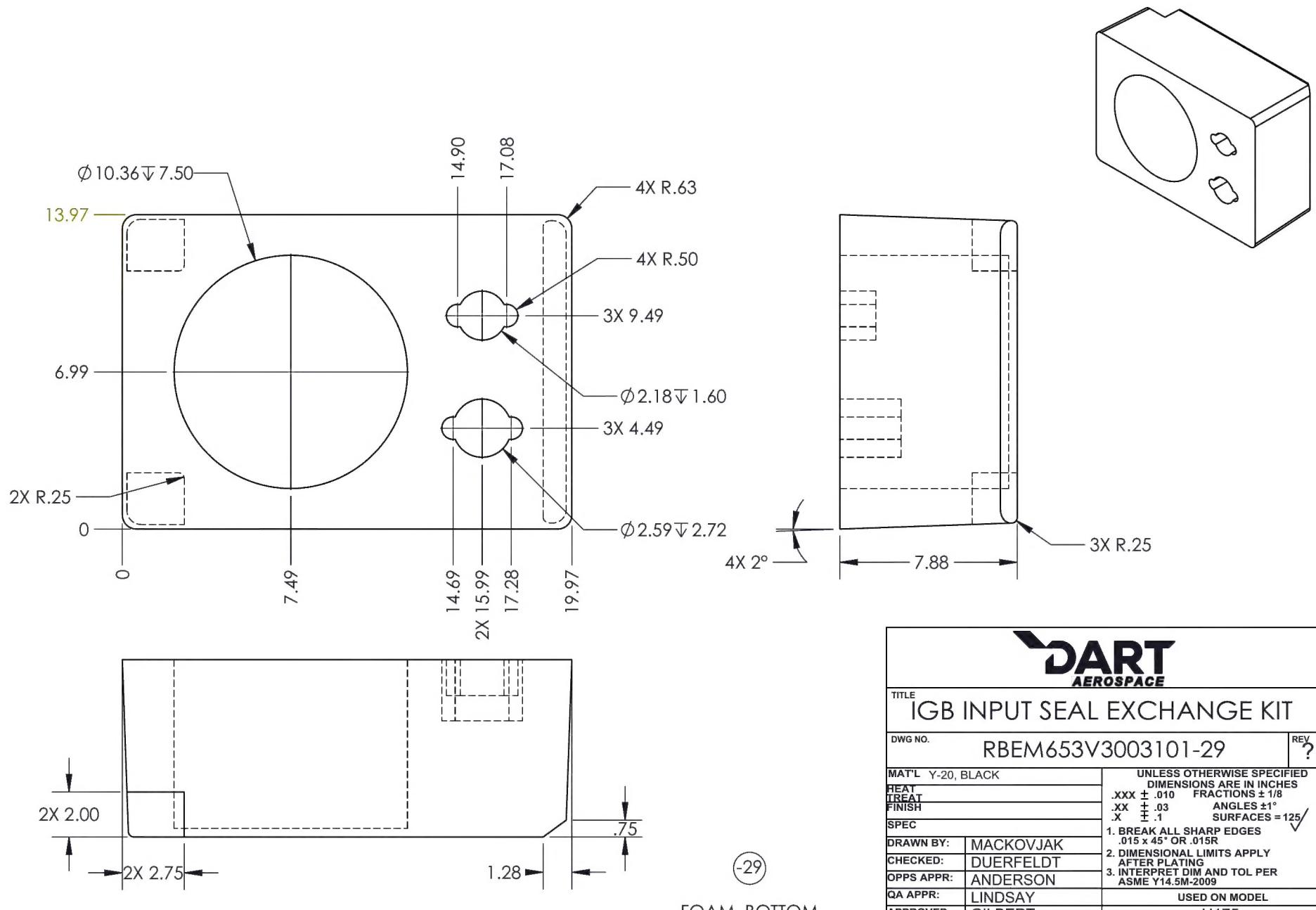
-27

FOOT

TITLE		DART AEROSPACE	
DWG NO.		RBEM653V3003101-27	
MAT'L		4140/4142 Q & T	
HEAT		UNLESS OTHERWISE SPECIFIED	
TREAT		DIMENSIONS ARE IN INCHES	
FINISH SEE -23		.XXX \pm .005 FRACTIONS \pm 1/8	
SPEC		.XX \pm .01 ANGLES \pm 5°	
DRAWN BY: MACKOVJAK		X \pm .1 SURFACES = 125 ✓	
CHECKED: DUERFELDT		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
OPPS APPR: ANDERSON		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
QA APPR: LINDSAY		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
APPROVED: GILBERT		USED ON MODEL H175	
SCALE	2:1	DATE	4/13/2016
SHEET 10 OF 13			

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REVISIONS						
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED	

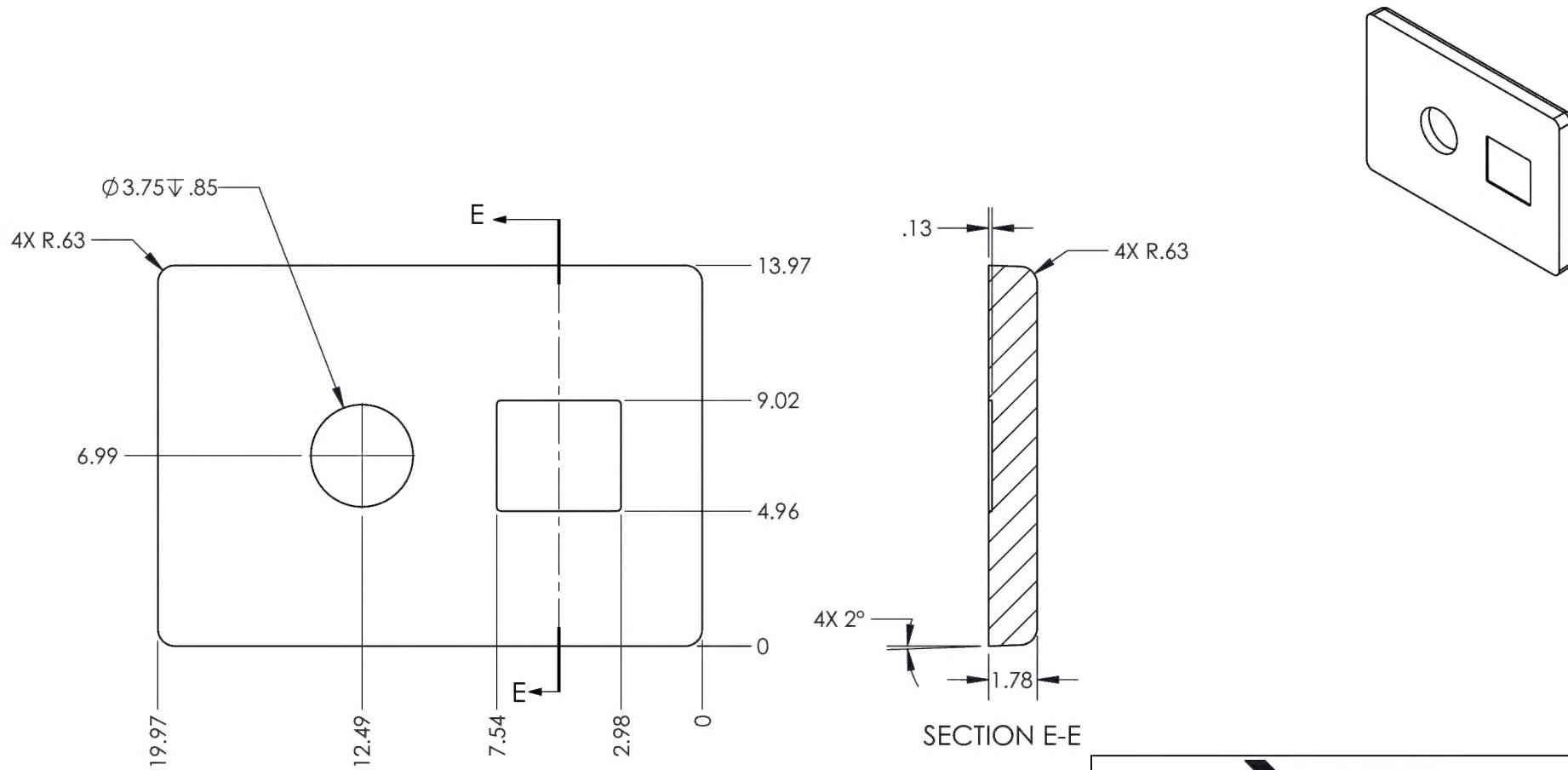


ITLE IGB INPUT SEAL EXCHANGE KIT

AT'L Y-20, BLACK		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
EAT		.XXX \pm .010 FRACTIONS \pm 1/8	
REAT		XX \pm .03 ANGLES \pm 1°	
NISH		X \pm .1 SURFACES = 125/	
PEC		1. BREAK ALL SHARP EDGES .015 X 45° OR .015R	
RAWN BY: MACKOVJAK		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
HECKED: DUERFELDT		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
PPS APPR: ANDERSON		USED ON MODEL	
A APPR: LINDSAY		H175	
PPROVED: GILBERT			
SCALE	1:6	DATE	4/13/2016
		SHEET 11 OF 13	

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REV		ECR		DESCRIPTION		DATE	INITIAL	APPROVED
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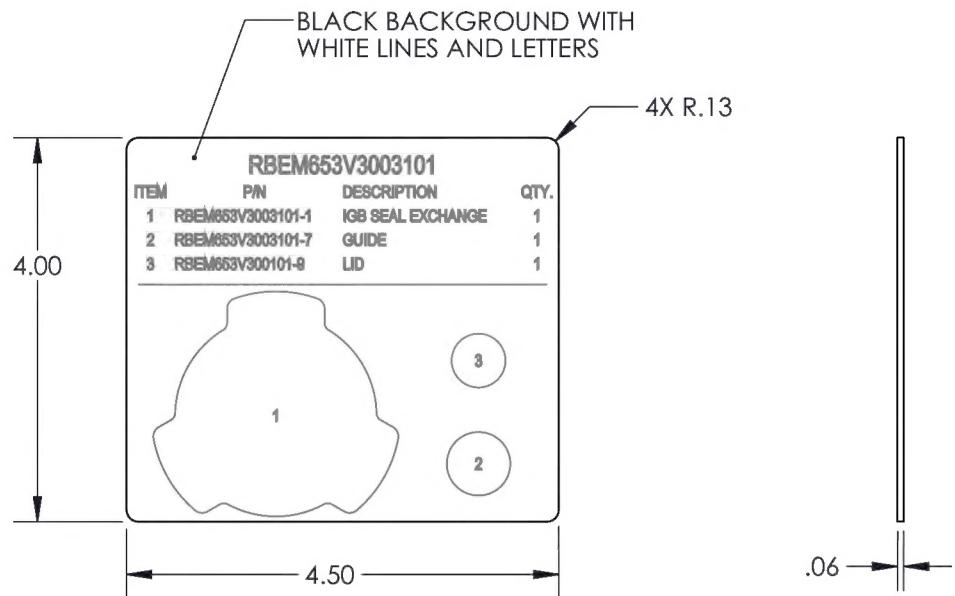
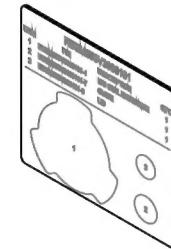
(-31)

FOAM, TOP

DART AEROSPACE	
IGB INPUT SEAL EXCHANGE KIT	
DWG NO.	RBEM653V3003101-31
REV <input type="checkbox"/>	
MAT'L	Y-20, BLACK
HEAT	UNLESS OTHERWISE SPECIFIED
TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX \pm .010 FRACTIONS \pm 1/8
SPEC	.XX \pm .03 ANGLES \pm 1°
DRAWN BY:	MACKOVJAK
CHECKED:	DUERFELDT
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	H175
SCALE	1:6
DATE	4/13/2016
SHEET 12 OF 13	

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REV	ECR	REVISIONS	DESCRIPTION	DATE	INITIAL	APPROVED
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NOTE:
USE PDF TO MANUFACTURE.

DART AEROSPACE	
TITLE	
IGB INPUT SEAL EXCHANGE KIT	
DWG NO. RBEM653V3003101-33	
REV ?	
MATERIAL PLASTIC	
HEAT TREAT	
FINISH	
SPEC	
DRAWN BY: MACKOVJAK	
CHECKED: DUERFELDT	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:2	DATE 3/13/2016
SHEET 13 OF 13	

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
.XXX ± .010 FRACTIONS ± 1/8
.XX ± .03 ANGLES ± 1°
X ± .1 SURFACES = 125 ✓

1. BREAK ALL SHARP EDGES
.015 x 45° OR .015R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009

USED ON MODEL
H175